

Work Order ID 75121

October-17-11 2:44:54 PM

\*75121\*

Page 1

Item ID: D3281-2L02

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Floor Protector, Fwd RH (Black)

Stop

\*NS2\*

Start Date: 17/10/2011 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/11 Tooling: Date:

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3281	Rev F								
DSI 9504	A								

100 0.00

\*100\* HAND FINISHING THERMOFORMING

Thermoform

0.00

Thermoforming Machine

Memo

Cut Blanks

x4 Dh  
11/10/18

105 0.00

\*105\* Dry Material

HandThermo

0.00

Hand Finishing Thermoforming

Memo

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 3:30pm

Time OUT: 8:00pm

x45 Dh  
11/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



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Page 3

Item ID: D3281-2L02

Accept

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Setup

Start

\*NS1\*

Revision ID:

Item Name: Floor Protector, Fwd RH (Black)

Start Date: 17/10/2011 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

140

QC2- Inspect parts off machine FAI/FAIB

\*140\*

QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Quality Control

Memo

0.00

Subtotal

X4

Dh  
11/10/18

160

\*160\*

Packaging

Packaging

Packaging

Memo

0.00

0.00

(4x) Sp 11-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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October-17-11 2:44:54 PM

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Page 4

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\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Floor Protector, Fwd RH (Black)

Start Date: 17/10/2011 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

170

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

\*170\*

QC

Quality Control

Memo

0.00

11/10/2011

11/10/2011

W/O:		WORK ORDER CHANGES					
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**Picklist Print**

October-17-11 2:45:00 PM

Page 1

Work Order ID: 75121

**\*75121\***

Parent Item: D3281-2L02

**\*D3281-21 02\***

Parent Item Name: Floor Protector, Fwd RH (Black)

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

**Comments:**

IPP Rev:A04.07.01New issueKJ/JLM

IPP Rev B 07.08.07 Thermoform in house DL  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No				sf	650.6276		17.332			

**\*MI FXS 093-F6006-02\***

GE PLASTICS LEXAN SHEET

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
therm	650.62758	
106751	105.89	
110877	544.73758	

*17.332 sq ft.**1/10/11*

W/O:		WORK ORDER CHANGES					
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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	75121
<b>Description:</b> Floor Protector, Fwd RH	<b>Part Number:</b>	D3281-2
<b>Inspection Dwg:</b> D3281 <b>Rev:</b> F		<b>Page 1 of 1</b>

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

### Measured b

Degree.

Date:

18/10/18

## TRIMMING SECTION

**Measured by:**

91.

Date: \_\_\_\_\_

11/10/19

**Audited by:**

1

Date:

u (10/03)

### Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.07.23	Dwg Rev updated	KJ/DL	
D	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	
E	10.09.01	Dwg Rev updated	KJ	
F	11.06.21	Dwg Rev updated	KJ	<i>[Signature]</i>

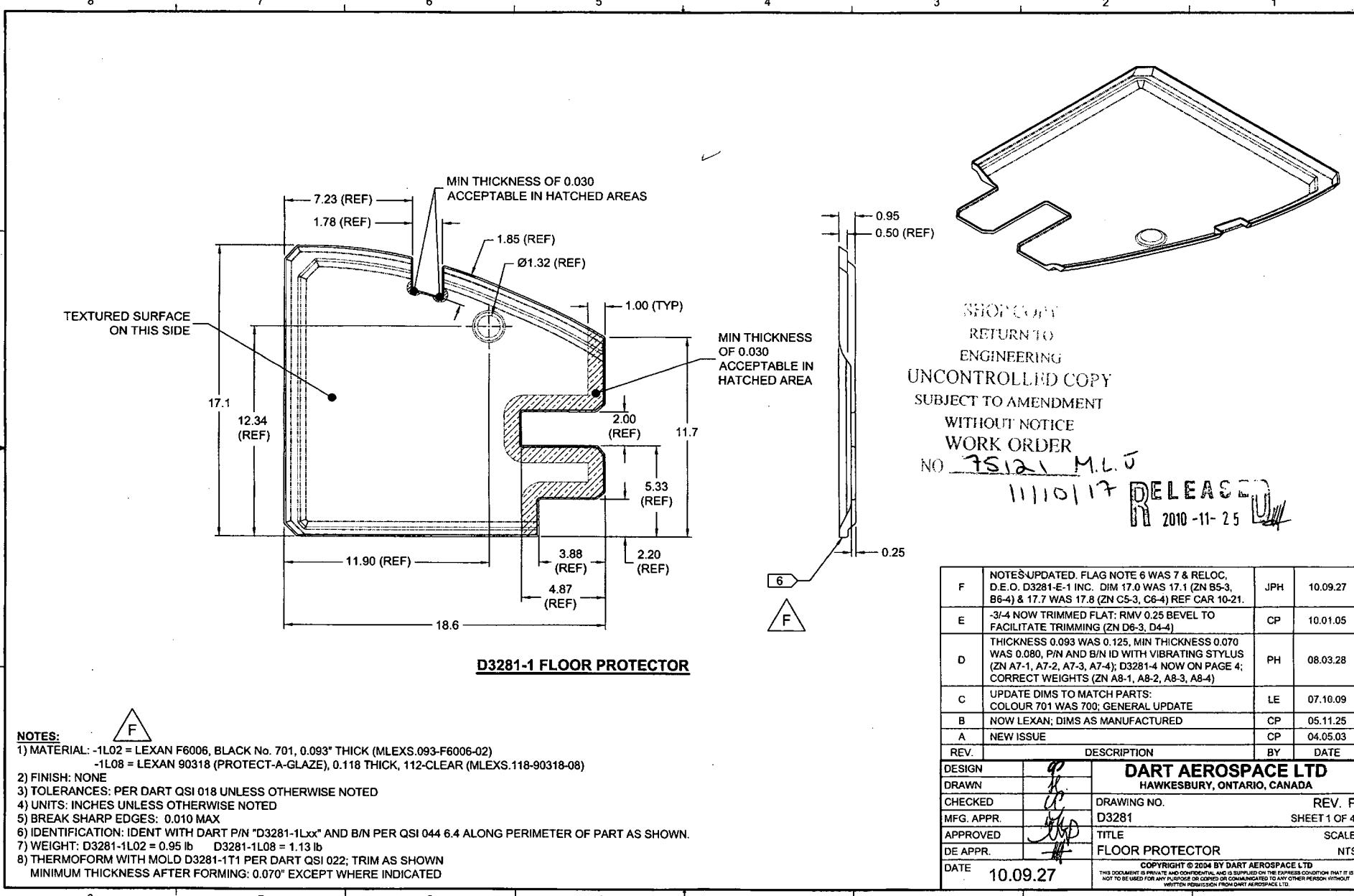
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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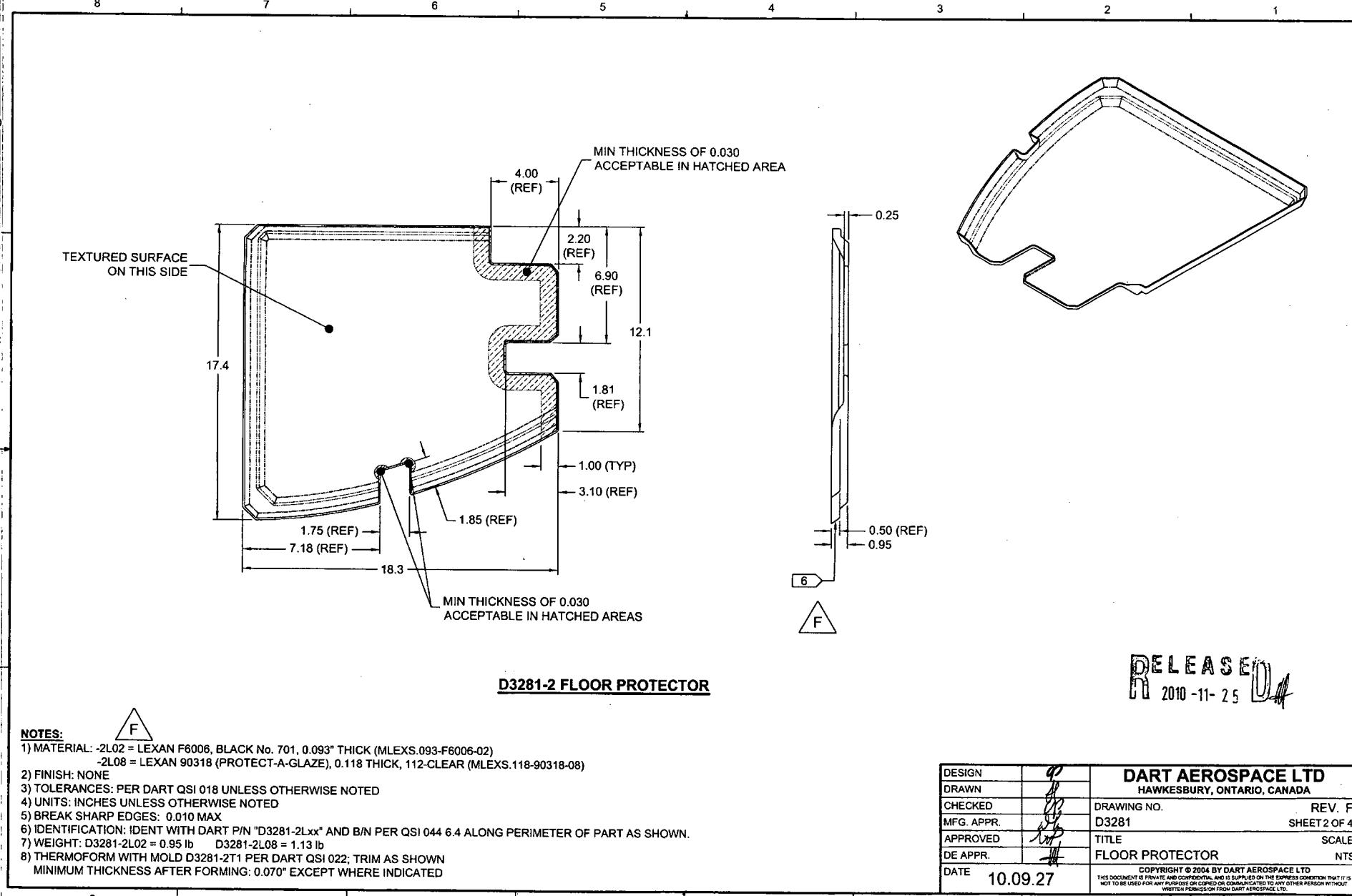
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75121

RELEASED  
2010-11-25

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

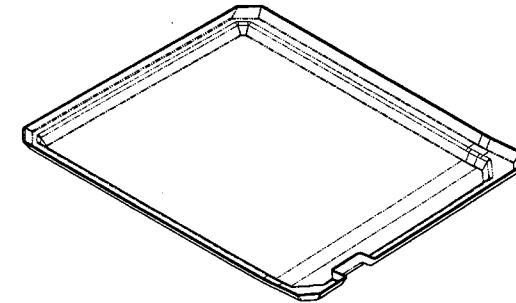
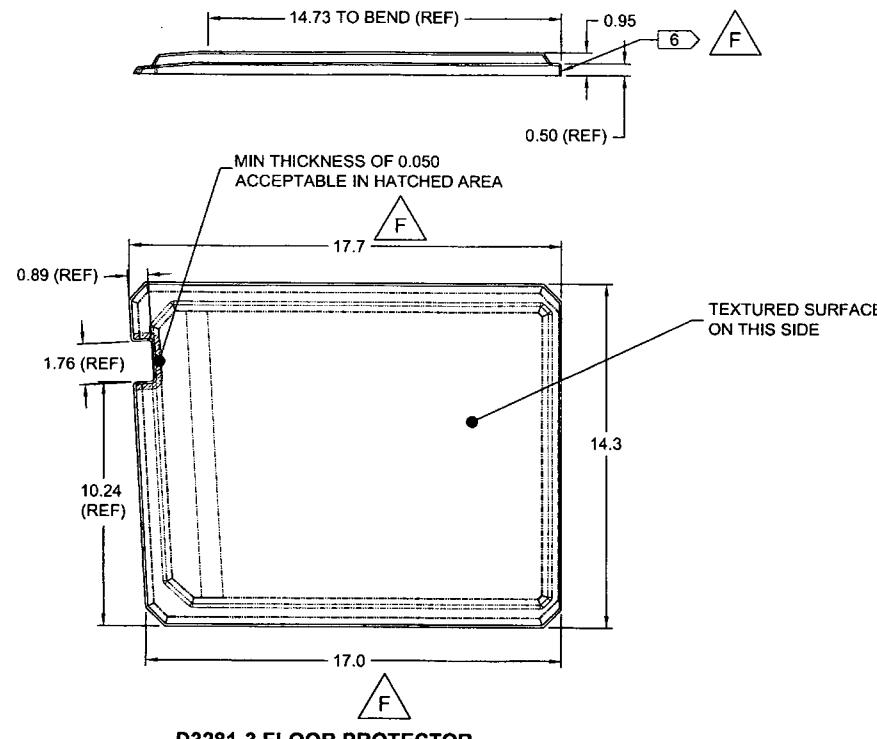
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NOTE: Date & initial all entries

75121

8 7 6 5 4 3 2 1



RELEASE  
2010-11-25



## NOTES:

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)  
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-3Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-3L02 = 0.87 lb D3281-3L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

8 7 6 5 4 3 2 1

DESIGN	90	<b>DART AEROSPACE LTD</b>
DRAWN	8	HAWKESBURY, ONTARIO, CANADA
CHECKED	10	DRAWING NO. REV. F
MFG. APPR.	10	D3281 SHEET 3 OF 4
APPROVED	10	TITLE
DE APPR.	10	SCALE
DATE	10.09.27	NTS

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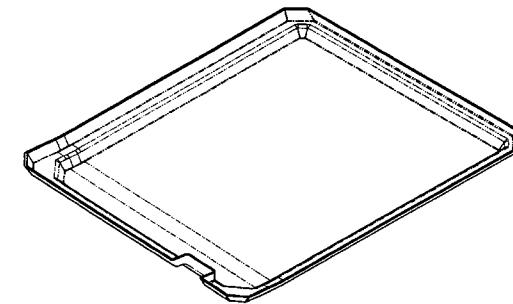
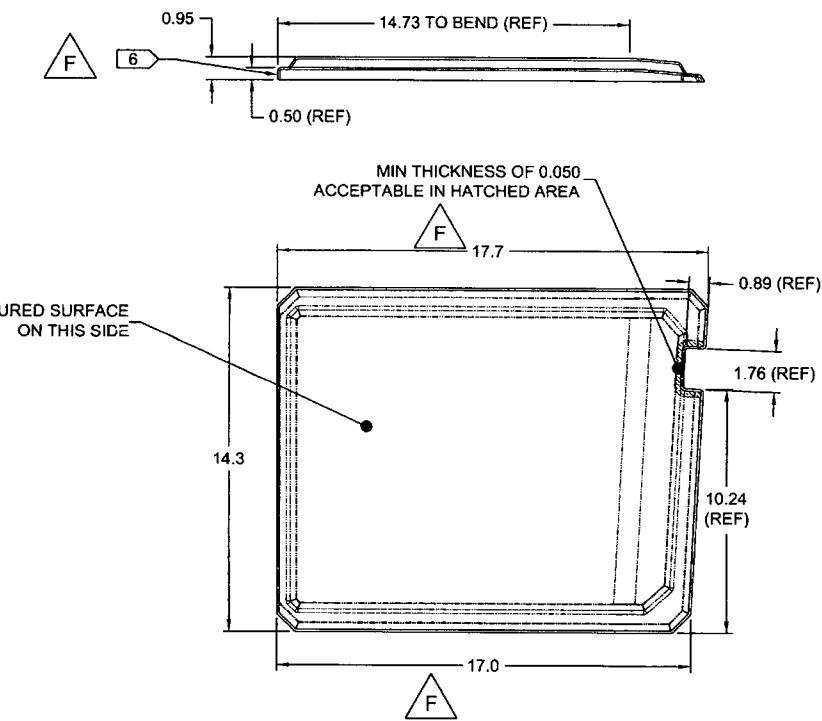
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75121

8 7 6 5 4 3 2 1



### D3281-4 FLOOR PROTECTOR

#### D3281-4 NOTES:

- 1) MATERIAL: 4L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)  
4L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-4Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-4L02 = 0.87 lb D3281-4L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

8 7 6 5 4 3 2 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3281	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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RELEASED  
2010-11-25 

W/O:		WORK ORDER CHANGES					
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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-719 REV. A  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D044-719 REV. 0

REF TCCA STC: SH04-40

REF FAA STC: SR02051NY

REF EASA STC: EASA.1M.R.S.01075

**PURPOSE:**

To add the D044-719-011L08 Clear Cabin Floor Protectors. The -011L08 kit is similar to the existing -011 kit, however the plastic is transparent instead of solid black. The existing D044-719-011 kit will be re-identified as D044-719-011L02.

**CHANGE:**

The D044-719-011L08 Cabin Floor Protectors kit consists of four transparent plastic trays that are placed on the cabin floor to protect the carpets from damage. The -011L08 kit should be installed per the -011 kit of Installation Instructions IIN-D044-719 and maintained per Instructions for Continued Airworthiness ICA-D044-719. The parts list and weight & balance for the -011L08 kit is given below.

**PARTS LIST**

QTY -011L02	QTY -011L08	Part Number	Description
X		D044-719-011L02	Cabin Floor Protectors (Black)
	X	D044-719-011L08	Cabin Floor Protectors (Clear)
1		D3281-1L02	Floor Protector, Fwd LH, Black
	1	D3281-1L08	Floor Protector, Fwd LH, Clear
1		D3281-2L02	Floor Protector, Fwd RH, Black
	1	D3281-2L08	Floor Protector, Fwd RH, Clear
1		D3281-3L02	Floor Protector, Aft LH, Black
	1	D3281-3L08	Floor Protector, Aft LH, Clear
1		D3281-4L02	Floor Protector, Aft RH, Black
	1	D3281-4L08	Floor Protector, Aft RH, Clear
8	8	D2854-1-100	Looped Velcro Strip
8	8	D2854-3-100	Hooked Velcro Strip

**WEIGHT AND BALANCE**

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D044-719-011L02	3.9 lb	0 in	0 in-lb	50 in	195 in-lb
Cabin Floor Protectors	1.8 kg	0 m	0 m-kg	1.27 m	2.3 m-kg
D044-719-011L08	4.4 lb	0 in	0 in-lb	50 in	220 in-lb
Cabin Floor Protectors	2.0 kg	0 m	0 m-kg	1.27 m	2.5 m-kg

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	10.02.24
CERT. NO.:	SH04-40
ISSUE NO.:	1

A	NEW ISSUE		CP	10.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	#P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	#P			
CHECKED	#	DRAWING NO. DSI 9504		REV. A
MFG. APPR.	N/A			SHEET 1 OF 1
APPROVED	#	TITLE FLOOR PROTECTOR KIT, CLEAR		
DE APPR.	#			
DATE	10.02.24			

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